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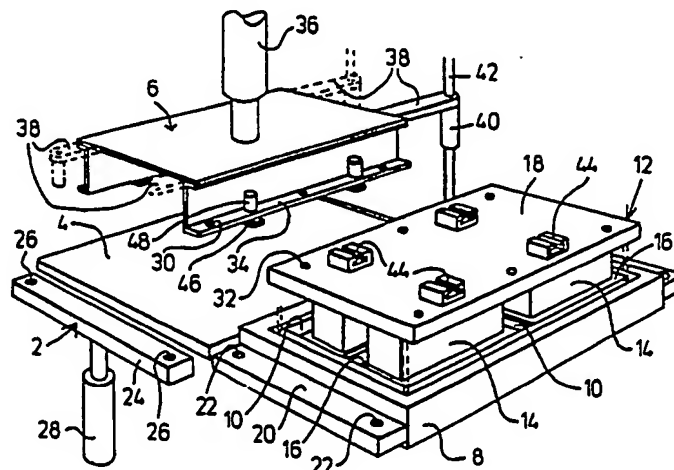
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(54) A method of mounting a mould system in a block stone moulding machine, and a correspondingly adapted moulding machine and mould system

(57) In machines for moulding block stones a cellular mould (8) is used underneath a compacting head (12) having press plates (16) that can be pressed down for compressing the concrete mass in the moulding cells (10) and for pressing out the moulded stone members when the mould is raised. The mould (18) is fixed to lower carrier means (24) and the compacting head (12) to an overlying carrier head (6) in a mutually accurately centered manner, which requires high accuracies in the making of holes for the spanner bolts, while also the mounting of the compacting head is difficult to carry out. According to the invention the compacting head is directly precentered in the mould (12) by means of distance pieces (52), and the entire mould unit (8, 12) thus preassembled, is moved into the space between the carrier head (6) and the carrier means (24) for the mould (8), whereafter the mould (8) is secured to the carrier means. By the insertion of the mould unit into the said space a 'floating' engagement is established between co-acting holding portions (44, 46) at the lower side of the carrier head (6), and upon fixation of the mould (2) working cylinders (48) are actuated to pull up the holding portions (46) of the carrier head for clamping the compacting head in its centered position. Thereafter the distance pieces are removed and the machine is ready for operation. Thus, the compacting head will be very easy to mount, and generally very coarse tolerances can be used.



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